

Date: Thursday, 14/02/2008 12:47:33 PM
 User: Dominique Dube

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP ASSY
 Job Number : 37300
 Estimate Number : 13163
 P.O. Number :
 This Issue : 14/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 07/02/2008 Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A new issue 08-02-07 DD verified by:

Part Number : D3724042
 Drawing Number : D3724 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 08/02/2008 Qty: 2 Um: Each

POSITIVE RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion B35618

Check Material for any Dents or Defects

08.02.08 2

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D3737-1 as per dwg D3737

2-Cut D3738-1 as per dwg D3738

3-Deburr and bevel ends for welding

08.02.08 2

08.02.08 2

08.02.08 2

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/12 (42)

4.0 D37331 GUSSET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUSSET
 batch B37297

08.02.12 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/02/2008 12:47:33 PM
User: Dominique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

2-Grind flush

Handwritten: 08-02-12 2
08-02-12 2

6.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

Handwritten: 08-02-12 (2)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/02/12 (2)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 08-02-12 2

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-02-12 (2)

10.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate *Handwritten:* B 34485

Handwritten: 08-02-12 2

11.0	D37281	PLATE
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

PLATE

batch *Handwritten:* 37299

Handwritten: 08-02-12 2

12.0	D37291	PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLATE

batch *Handwritten:* 37298

Handwritten: 08-02-12 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37301	ANGLE
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
ANGLE 37306
batch 3703

✓

14.02.04 2

14.0	D37411	ANGLE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
ANGLE
batch 37307

✓

14.02.14 2

15.0	MS20470AD511	Rivet
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)
Rivet
batch M101100

14.02.14 2

16.0	MS20470AD516	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Rivet
batch M101100

14.02.14 2

17.0	CR321354	Cherry Rivet
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)
Cherry Rivet
batch M101100

14.02.14 2

18.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Apply Magnobond before installing rivets M104677
A/R Magnobond 6398 Batch: M106466

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

PTO
14.02.14 2

14.02.14 2

14.02.14 2


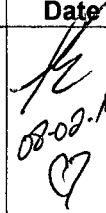



14.02.14 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/14	18.0	BRACKET HOLES WERE DRILLED AT WRONG LOCATION. R.C.I. MEASUREMENT INCLUDED THE AFT CAP ON THE DWG. EMPLOYEE ADDED AFT CAP DIM. TO MEASUREMENT. HUMAN ERROR	 08/02/14	- GRIND & FILL HOLES WITH WELD AS PER Q51004 AND GRIND FLUSH. - RE-ALDINE AS PER Q51005	 08-02-14	 08/02/14	 08/02/14	 08/02/14

NOTE: Date & initial all entries

Date: Thursday, 14/02/2008 12:47:33 PM
User: Dominique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-reloadine holes

19.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Apply magnabond as per dwg D3724

A/R Magnabond 6398

Batch:

M104677

~~M104677~~

2-Rivet brackets in place on step as per dwg D3724

3-Weld both end cap as per Dwg D3724

4-Grind end cap welds flush

Inspect for foreign object per QSI 024

08-02-14

2

08-02-14

2

08-02-14

2

08-02-14

2

20.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-02-15 (2)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08-02-15

08-02-15 (2)

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08-02-15

(2X)

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005

BR 08-02-15

(2)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08-02-15

(2X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/02/2008 10:58:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



N1106 804



2X

Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

M.A.

08/02/15

26.0

QC5

INSPECT WORK TO CURRENT STEP



ONE WAS TAKEN FOR HAZ. IX



Comment: INSPECT WORK TO CURRENT STEP

08/02/19 (4)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

VE
08-03-07

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/19

29.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap on D3738-1 as per dwg D3724

2-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

3-Grind flush

VE
08-02-15

Job Completion



08/02/19

POSITIVE RECALL
EFFECTIVE 08/02/07 AUTH
RELEASED _____ DATE _____

Date: Thursday, 07/02/2008 3:09:39 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP ASSY
 Job Number : 37300
 Estimate Number : 13163
 P.O. Number :
 This Issue : 07/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-02-07 DD verified by:

Part Number : D3724041
 Drawing Number : D3724 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 08/02/2008 Qty: 2 Um: Each

POSITIVE
RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion B35618

Check Material for any Dents or Defects

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D3737-1 as per dwg D3737

2-Cut D3738-1 as per dwg D3738

3-Deburr and bevel ends for welding

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 D2734 206 Step Endplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:
 Qty Part Number Description Batch:
 2 D2734 End Cap B34425

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng		Action Description Chief Eng			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D37331

GUSSET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUSSET

batch

331247

H 08.02.12 2

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

~~1-Weld one end cap on D3738-1 as per dwg D3724~~

2-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

3-Grind flush

~~H 08.02.12 2~~

H 08.02.12 2

H 08.02.12 2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

H 08.02.12 2

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

H 08.02.12 2

9.0

D37281

PLATE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

PLATE

batch

10.0

D37291

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLATE

batch

11.0

D37301

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

ANGLE

batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-02-12	8 b). 8 c).	add a step before drilling holes. inspection Qc 3		FF	08-02-12 08-02-12	2 (2)		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D37411

ANGLE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

ANGLE

batch _____

13.0

MS20470AD511

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet

batch _____

14.0

MS20470AD516

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

batch _____

15.0

CR321354

Cherry Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Cherry Rivet

batch _____

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Magnobond 6398 Batch _____

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Debur

5 realodine holes

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

19.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Rivet brackets in place on step as per dwg D3724
*****LEAVE ONE RIVET OUT FOR WELDING*****

both
2-Weld ~~last~~ end cap as per Dwg D3724

3-Grind end cap welds flush
Inspect for foreign object per QSI 024

4-Install last rivet

21.0	QC9	VISUAL WELDING INSPECTION
------	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

22.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

23.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

24.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP ASSY

Job Number: 37300

Part Number: D3724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08/02/07 AUTH [Signature]

RELEASED _____ DATE 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

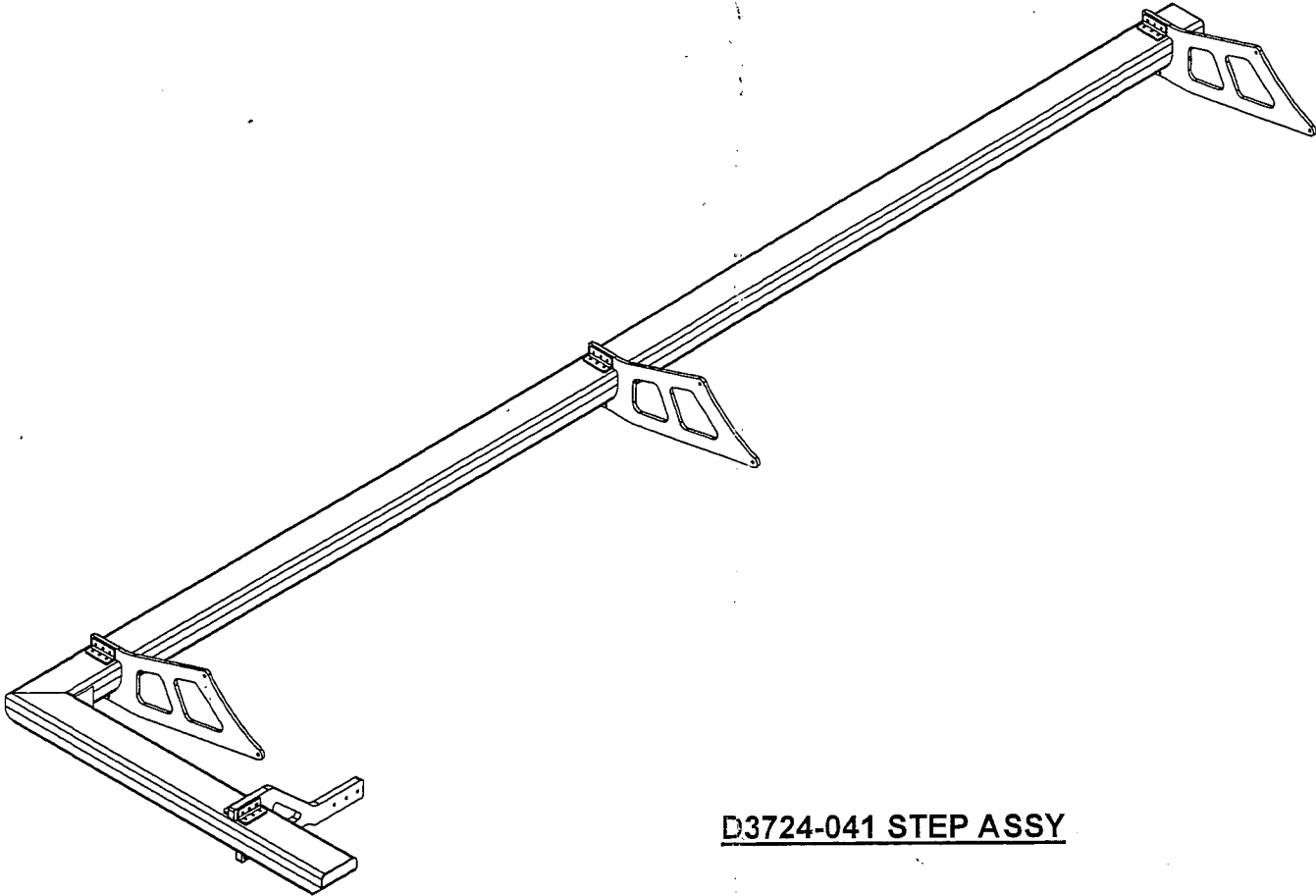
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY.	PART NUMBER	DESCRIPTION
X	D3724-041	STEP ASSY
2	D2734-1	END CAP
3	D3728-1	STEP BRACKET
1	D3729-1	STEP BRACKET
8	D3730-1	ANGLE
1	D3733-1	GUSSET
1	D3737-1	STEP
1	D3738-1	STEP
8	D3741-1	ANGLE
12	MS20470AD5-11	Rivet
4	MS20470AD5-16	Rivet
32	CR3213-S-4	Rivet

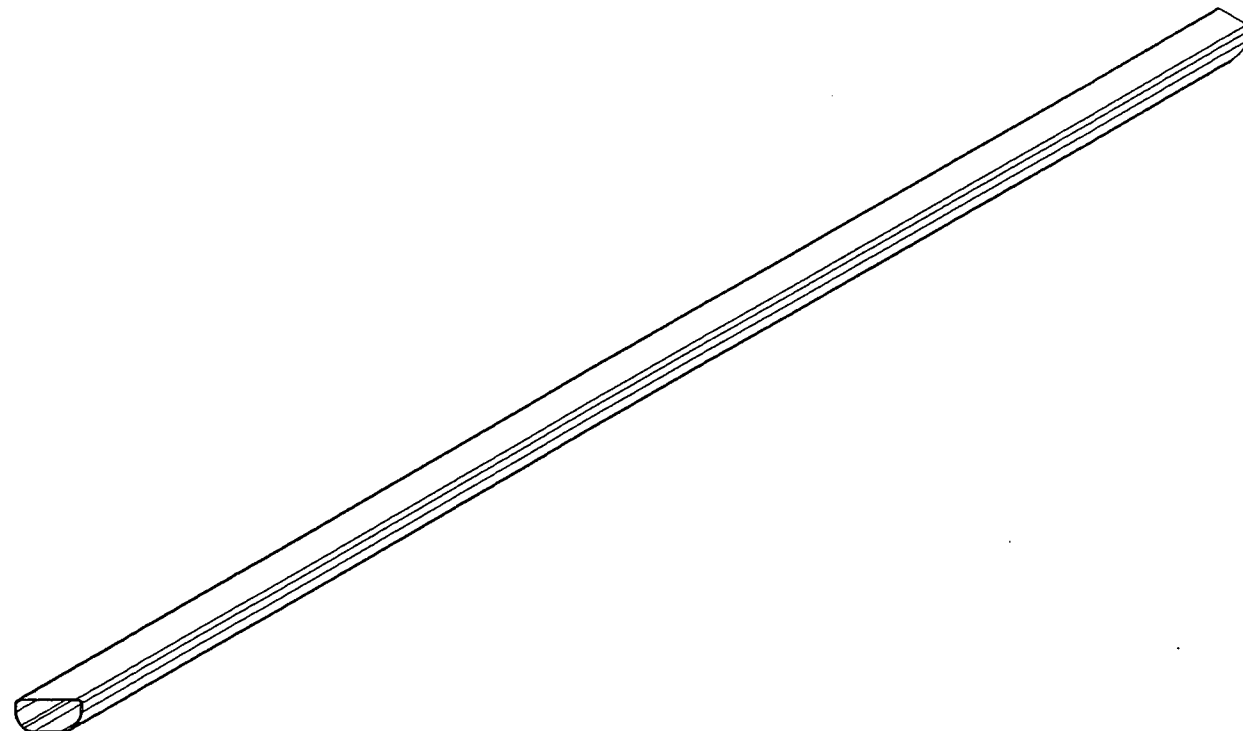


D3724-041 STEP ASSY

PRELIMINARY ISSUE
ISS 08.02.05

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3724-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 13.93 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	.	D3724	SHEET 1 OF 1
APPROVED	.	TITLE	SCALE
DE APPR.	.	STEP ASSY	NTS
DATE	08.02.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



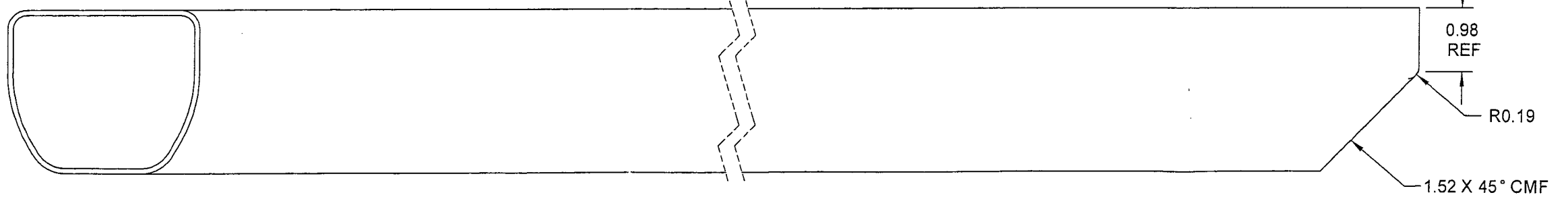
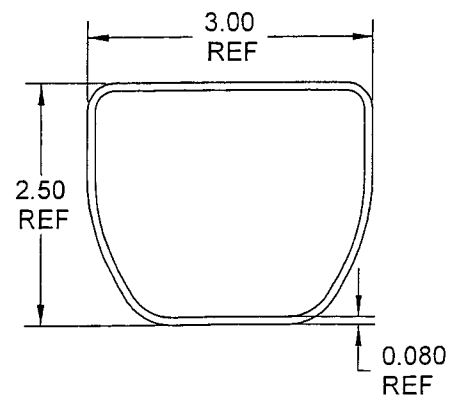
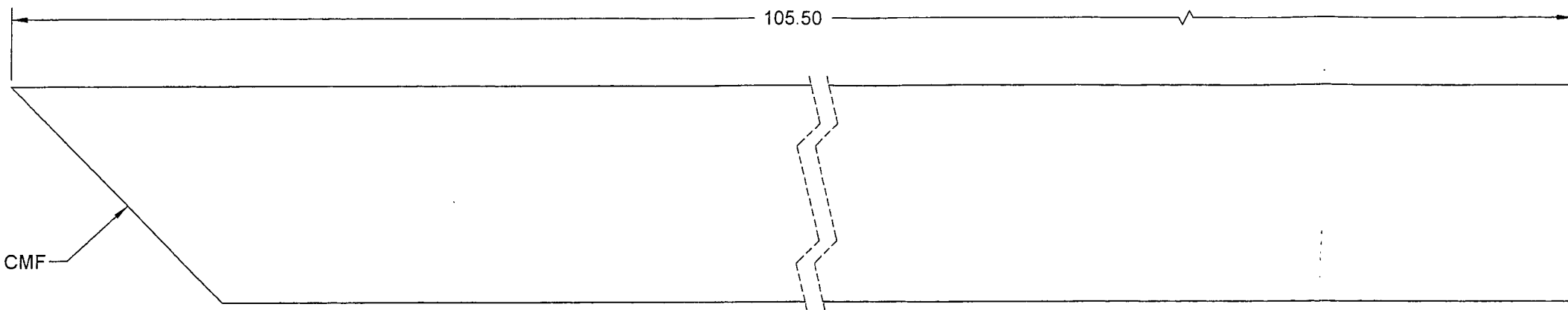
PRELIMINARY ISSUE
AJS 08.02.05

- NOTES:
- 1) MATERIAL: MAKE FROM D2622-106 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.67 lbs

A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3737		SHEET 1 OF 2
APPROVED		TITLE		SCALE
DE APPR.		STEP		NTS
DATE	08.02.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

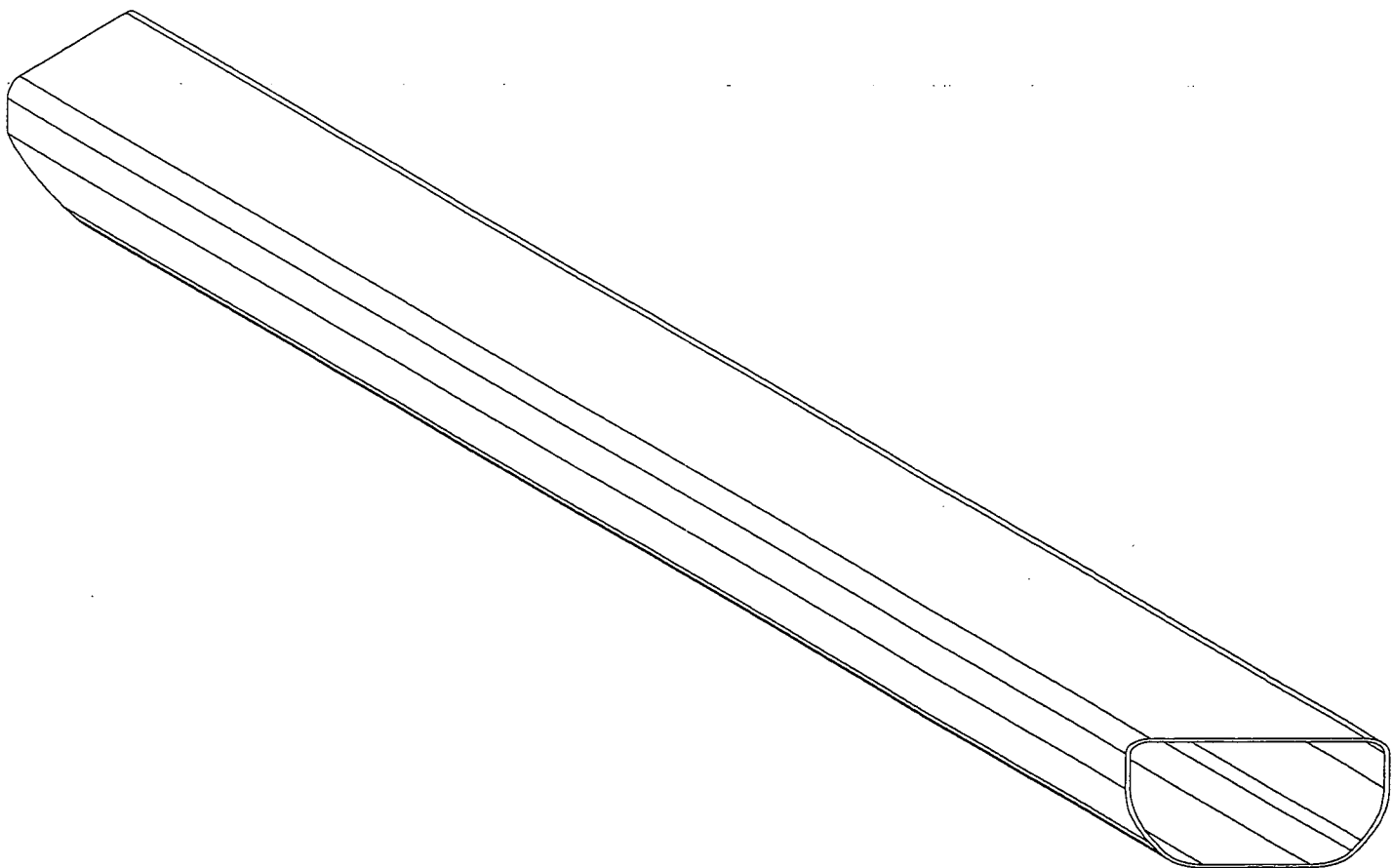
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PRELIMINARY ISSUE
ASS 08.02.05



D3737-1 STEP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3737	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP	1:2
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PRELIMINARY ISSUE
ASS 08.02.05

- NOTES:
- 1) MATERIAL: MAKE FROM D2622-29 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.48 lbs

A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO. D3738		REV. A
MFG. APPR.				SHEET 1 OF 2
APPROVED		TITLE STEP		SCALE
DE APPR.				NTS
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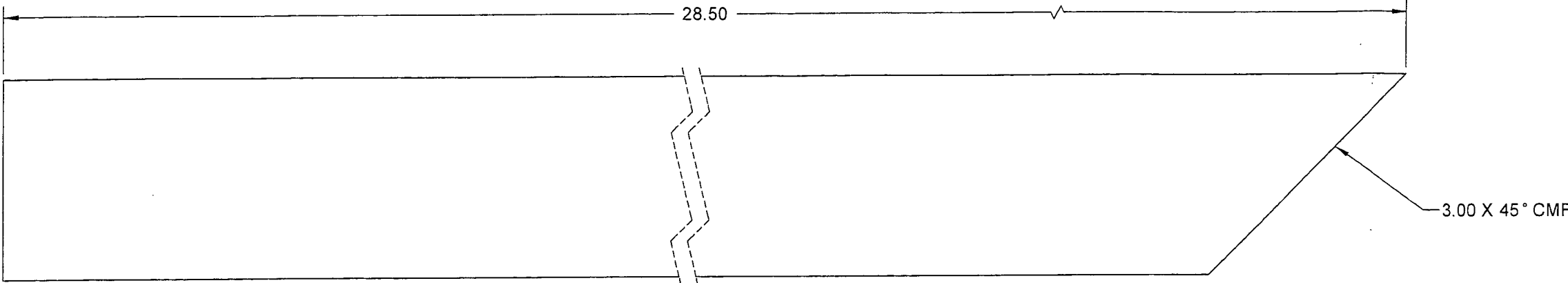
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D

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ASS 08.02.05

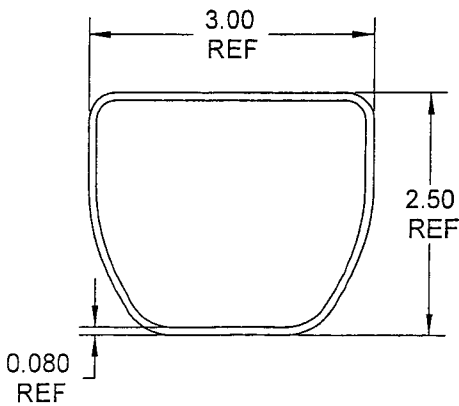
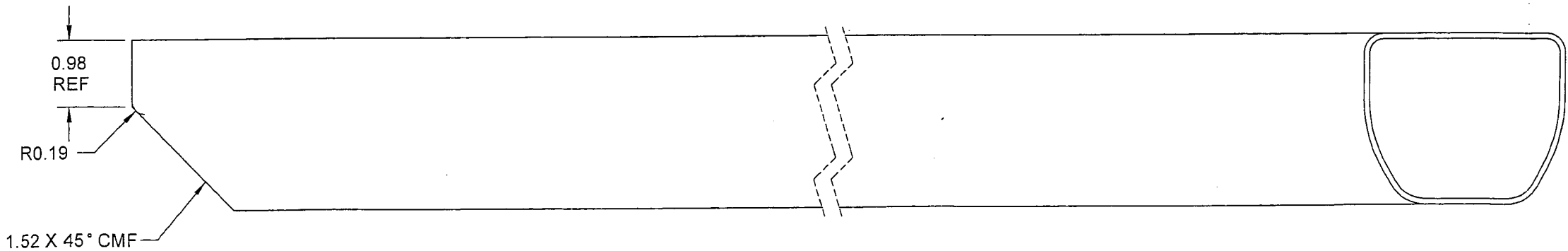
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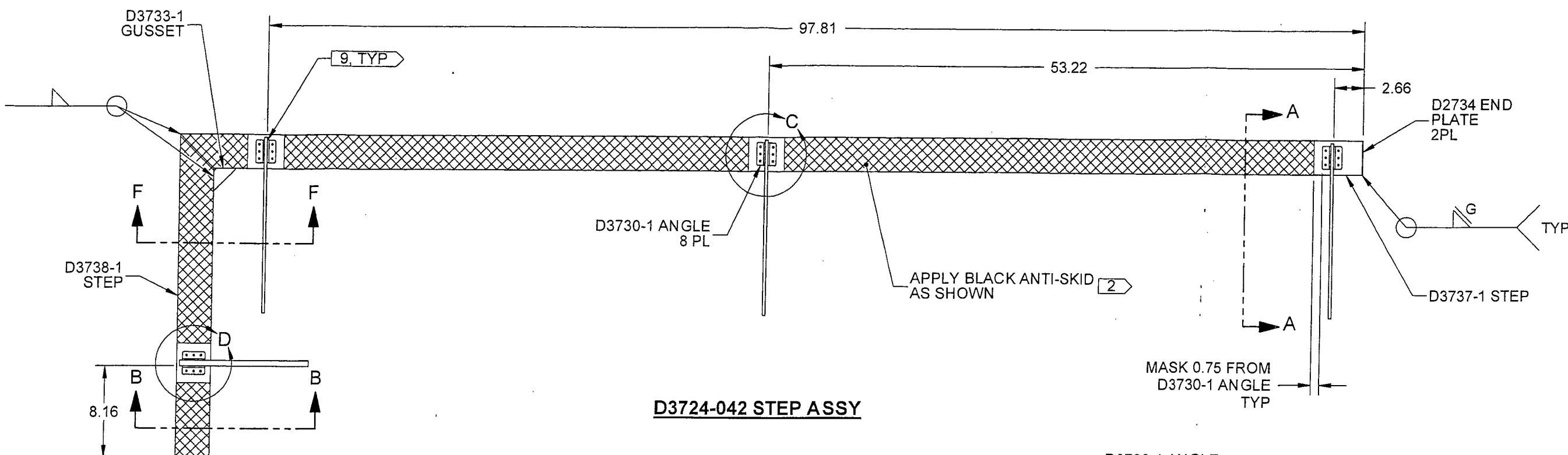
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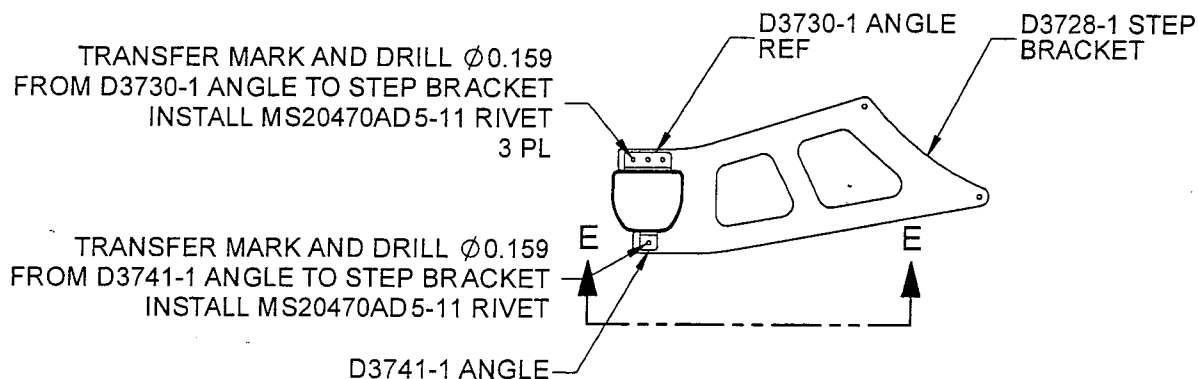
D3738-1 STEP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3738	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP	1:2
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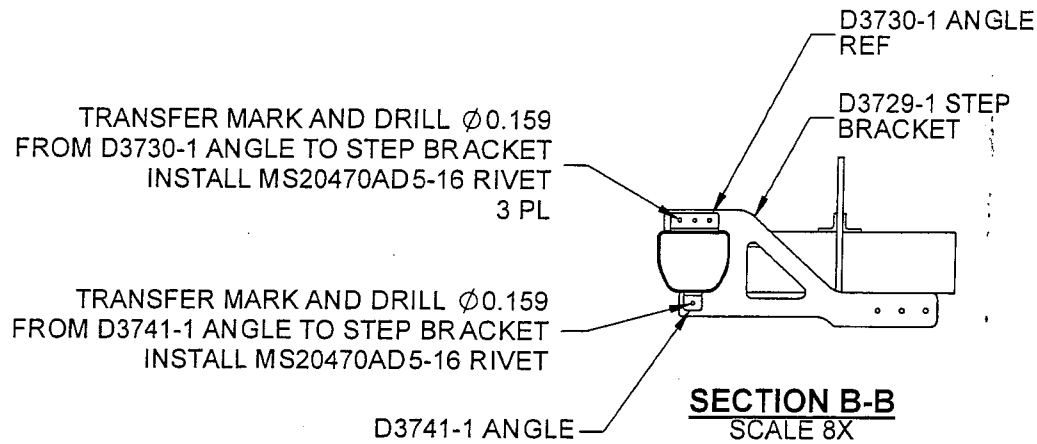
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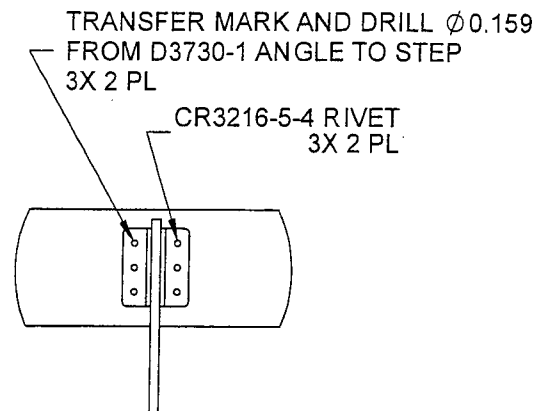
D3724-042 STEP ASSY



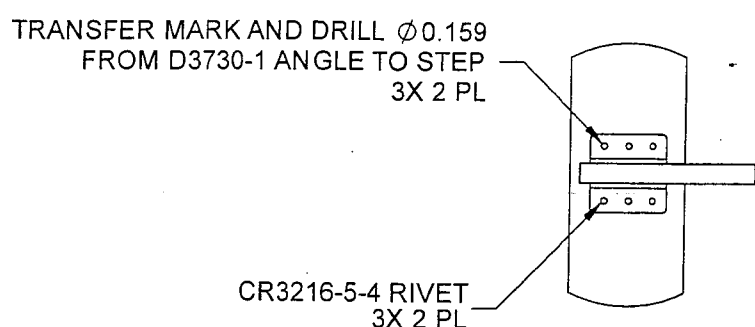
SECTION A-A
SCALE 8X
(TYP, 3 PL)



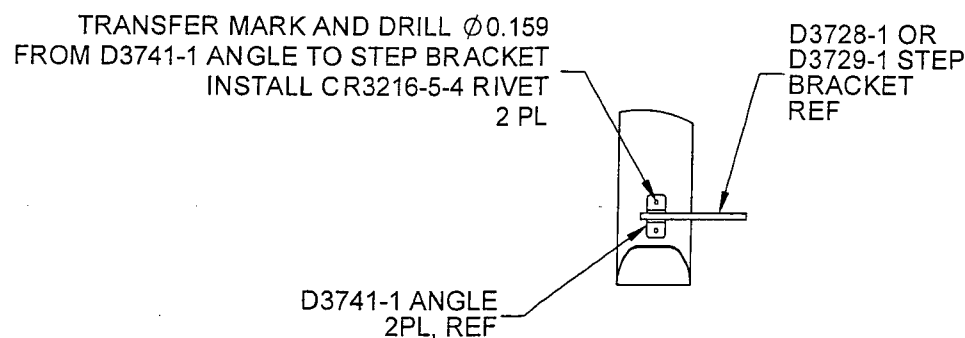
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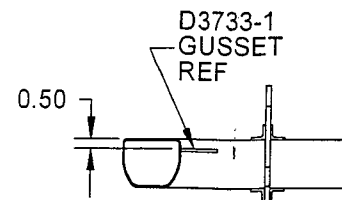
DETAIL C
SCALE 5X
(TYP, 3 PL)



DETAIL D
SCALE 5X



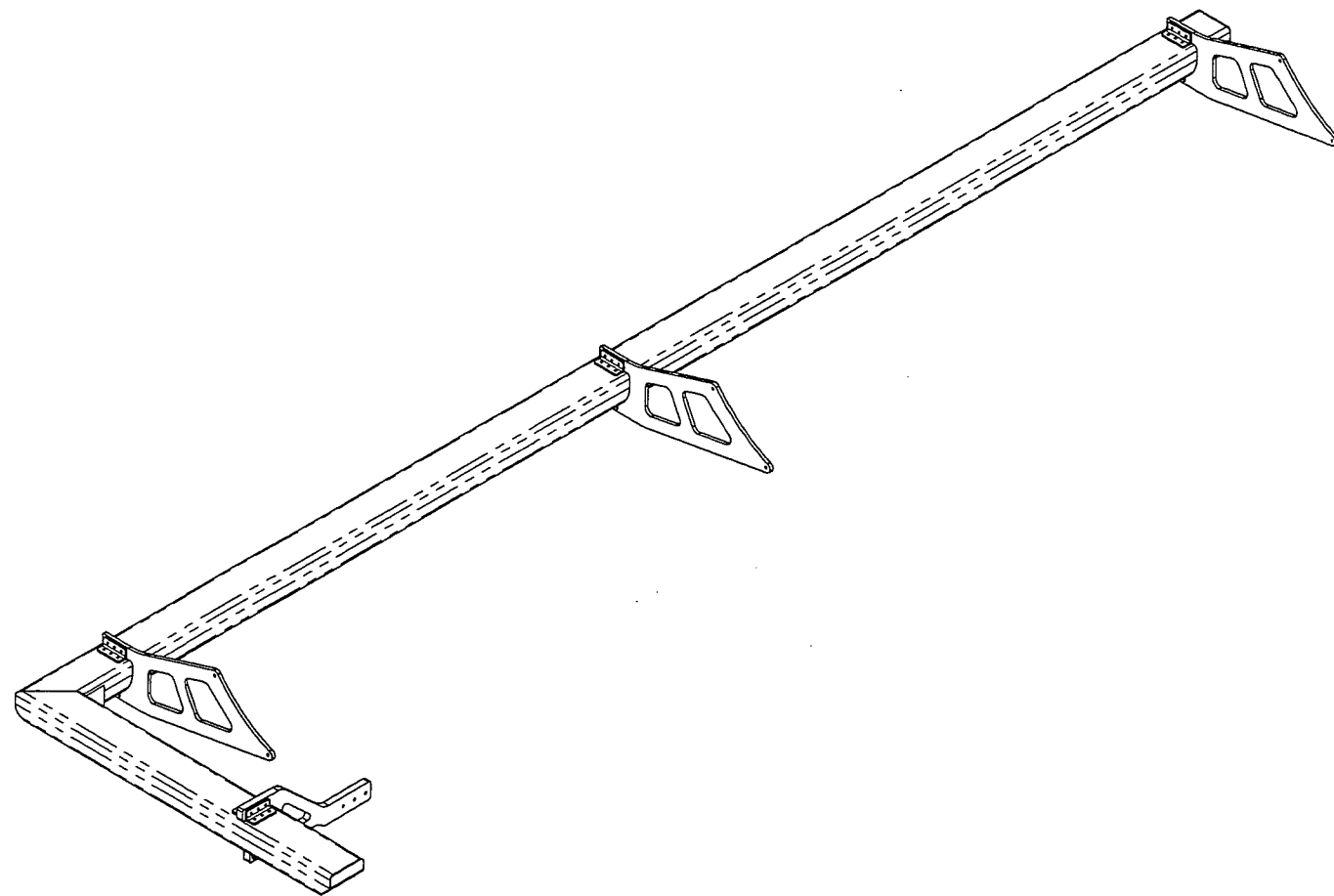
SECTION E-E
SCALE 8X
(TYP, 4 PL)



SECTION F-F
SCALE 10X

PRELIMINARY ISSUE
LE 08.02.15

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO. D3724	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE STEP ASSY	SCALE NTS
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DATE	08.02.04		



D3724-042 STEP ASSY

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 13.91 lbs
 - 8) WELDING: PER DART QSI 004
 - 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED

QTY -042	P/N	DESCRIPTION
X	D3724-042	STEP ASSY
2	D2734-1	END PLATE
3	D3728-1	STEP BRACKET
1	D3729-1	STEP BRACKET
8	D3730-1	ANGLE
1	D3733-1	GUSSET
1	D3737-1	STEP
1	D3738-1	STEP
8	D3741-1	ANGLE
32	CR3216-5-4	RIVET
3	MS20470AD5-11	RIVET
1	MS20470AD5-16	RIVET

PRELIMINARY ISSUE
LE 08.02.15

A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3724	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	LE	STEP ASSY	NTS
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